August 26, 2009 10:53:31 AM

Item ID:

D2230-3

Revision ID: G

Item Name: Lug

Start Date:

8/25/09

Required Date: 9/04/09

Start Qty: 160.00 Req'd Oty: 160.00

08.01.26

Reference:

Approvals:

QC:

Date:

Date:

Tooling:

Accept

SPC (Y/N):

Set Up/

Run Hours

Draw Number

Cust Item ID:

Customer:

Draw Rev.

Date:

Date:

Plan Code

ml/4.A 09/09/04 160 &

Accept Qty

Run

Reject **Qty**

Setup Start

Stop

Start

Stop

Reject Number

Insp. Stamp

Draw Nbr

Sequence ID/

Work Center ID

Revision Nbr

D2230

Rev G

Jeaspa Bandsaw

Bandsaw

BAND SAW

Operation

Description

Memo

Band Saw : Cut D2423 extrusion to 0.82"

0.00

0.00

Batch: 45800

110

HAAS I

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Memo

0.00

0.00

Machine per folio D2230-31 iCheck for crack while loading into the machine.

120

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

MA 09/09/09/16

A.A 09/09/09 / SL 09/09/16

0.00

	•								
W/O:			WO	RK ORDER CHANG	ES	And the second s			
DATE STEP		PRO	OCEDURE CHAN	DURE CHANGE By Da			Approval Chief Eng / Prod Mgr	ng / Approva	
						,			
Part No	:	PAR #: \	Fault Categ	jory:	NCR: Yes	No DQA:	Date: _		
	Reso	lution:	Disposition	:	_ QA: N/C Cld	sed:	Date: _		
NCR:		\	WORK ORDE	R NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC			on B	Verification	Approval	Approval	
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Chief Eng	QC Inspector
				·					
				•					

Work Order ID 51568

G

August 26, 2009 10:53:31 AM

Item ID:

D2230-3

Revision ID:

Item Name: Lug

Start Date:

8/25/09

Required Date: 9/04/09

Start Qty: 160.00 Req'd Qty: 160.00

Operation

Description

Small Fab

Reference:

Approvals:

QC:

Process Plan:

Tooling:

Set Up/

Run Hours

0.00

0.00

0.00

0.00

Date: Date:

QC8- Inspect parts - second check

Memo

Memo

SPC (Y/N):

Accept

Cust Item ID:

Customer:

Draw

Number

Date: Date:

Draw

Rev.

Plan

Code

Run Start

Setup Start

Stop

Stop

Reject

Qty

Sequence ID/ Work Center ID 130

Quality Control

140

Small Fab

Small Fab

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

Memo

0.00 20 09/09/16

0.00

Reject Insp. Number Stamp

Qty

Accept

160 0

11110	-		14.6							
W/O:	!		WC	ORK ORDER CHANG	ES					
DATE STEP		PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
							1			
				And a first field						
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date:		
	Re	esolution:	Disposition	n:	_ QA: N/C C	osed:		Date: _		
NCR:			WORK ORDI	ER NON-CONFORM	ANCE (NCF	R)				
DATE	STEP	Description of NC			ion B	Verification		Approval	Approval	
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	k Secti	Section C		Chief Eng	QC Inspecto
										
								İ		

Work Order ID 51568

G

August 26, 2009 10:53:31 AM

Item ID:

D2230-3

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Start Date:

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Required Date: 9/04/09

Start Qty: 160.00 Req'd Qty: 160.00

Reference:

Approvals:

QC:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

0.00

Accept

Setup Start



Stop

Cust Item ID:

Customer:

Run

Start



Stop

Sequence ID/ **Work Center ID**

160

Quality Control

Operation **Description**

QC3- Inspect Part Finish

Memo

Draw Number

Draw Rev.

Date:

Date:

Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

170

Powdercoat

Powder Coating

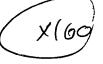
White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M([2 2 6 0]

0.00

0.00

Il 02/09/16



:OVEN TEMPERATURE:

180

Quality Control

QC3- Inspect Part Finish

Memo

0.00 bh 09-09-17

W/O:			WO	RK ORDER CHANG	ES			-		
DATE STEP		PR	PROCEDURE CHANGE			Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							:			
Part No.		PAR #:	Fault Catao		NCD.	V N	Is DOA		Data	
raitivo		olution:								
NCR:		· · · · · · · · · · · · · · · · · · ·		R NON-CONFORM						
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sect Action Description Chief Eng	tion B	Sign & Date	Verifica Sectio		Approval Chief Eng	Approval QC Inspector

Work Order ID 51568

August 26, 2009 10:53:31 AM

Item ID:

D2230-3

Revision ID: G

Item Name: Lug

Start Date:

8/25/09

Start Oty: 160.00 Required Date: 9/04/09

Req'd Qty: 160.00

Reference:

Approvals:

Sequence ID/

Work Center ID

Process Plan:

QC:

Date:

Date:

SPC (Y/N):

Tooling:

Set Up/

Run Hours

Accept

Packaging Packaging

190

Operation Description

Identify as per dwg & Stock Location:_

Memo

Memo

0.00

0.00

QC21- Final Inspection - Work Order Release

200

Quality Control

0.00

0.00

Setup Start



Stop

Cust Item ID:

Customer:

Draw

Number

Plan

Code

Date: Date:

Draw

Rev.

Run

Qty

Accept

Qty

Stop

Start

Reject Reject

Insp. Number Stamp

no 09-09-22

W/O:			W	ORK ORDER CHANG	SES			
DATE STEP		PR	PROCEDURE CHANGE			Date C	Approval Chief Eng / Prod Mgr	Approval QC Inspector
-1.								
								5
Part No		PAR #:						
	Re	esolution:	Disposition	n:	_ QA: N/C C	losed:	Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NC	R)		-
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Description Chief Eng	tion B Sign Date	& Verificati & Section C		Approval QC Inspector
<u> </u>			Oliidi Elig	Office Eng	Date			
		·						
] [<u>.</u>				

Picklist Print

August 26, 2009 10:53:30 AM

Work Order ID: 51568

Parent Item:

D2230-3RevG

Parent Item Name: Lug

Comments:

D2230-3PRevF



Start Date: 8/25/09

Start Qty: 160.00

Qty

Issued

Required Date: 9/04/09

Page 1

Status

Required Qty: 160.00

Date

Issued

Component Item ID/ Item Name

Replacement Mfg/ Item ID

Purch

Purchased

Bin Item Location

Primary Last Location

Route Unit of Seq ID

Measure Hand 0.0000

Qty on

Remaining Qty To Pick

160.0000

Manufactured

No

100

100

f

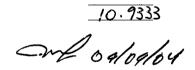
Each

724.9297 11.5032

Lug Extrusion

LUG D2423RevB1

Loc Qty	Loc Code	
724.92968		
213.01468		
22.39		
489.525		<u> </u>
	724.92968 213.01468 22.39	724.92968 213.01468 22.39



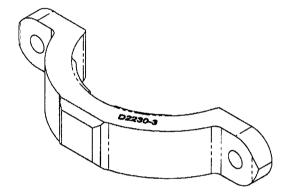
W/O:			WC	ORK ORDER CHA	ANGES					
DATE STEP		PRO	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
·										
Part No	•	PAR #:	Fault Cate	gory:	NCF	R: Yes	No DQ	4 :	Date: _	
	Re	solution:	Disposition	n:	QA:	N/C CId	sed:		Date: _	
NCR:			WORK ORDI	ER NON-CONFO	RMANCE	(NCR)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Descript Chief Eng	Section B	Sign & Date	Verific Secti		Approval Chief Eng	Approval QC Inspector
		٠.								
									,	

DART AEROSPACE LTD	Work Order:	51568
Description: Mounting Lug	Part Number:	D2230-3
Inspection Dwg: D2230 Rev: F		Page 1 of 1

	FIRS	TARTICLE IN	ISPECTI	ON CHE	ECKLIST		
	x	First Artic	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection		omments
4.450	+/-0.010	4.450	~				
0.413	+/-0.010	0.413	V				
0.306	+/-0.010	0.306	V				
3.700	+/-0.010	3.699)				
0.750	+/-0.010	0.751	~				
Ø0.257	+0.005/-0.000	\$ 0.259	~				
0.375	+/-0.010	0.3755	>				
R1.200	+/-0.010	R1.200	~				
0.100 x 45°	+/-0.010	0.094 x45°	\checkmark				
		Budited have	01		Prototype Ar	proval:	N/A
Measured by: Date:	M.A 09/09/09	Audited by:	8/- 12/04/16	+	i lototype A	Date:	19/7
Rev Date	Change		/ / "			Revised b	
A 03.11.11	New Issue					KJ/RF 🕏	FT 14

D2230-1

D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

51568



DESIGN BW DRAWN AJS			DART AEROSPA HAWKESBURY, ONTARI		
REV.				BY	DATE
С	RE-DES	IGN		BW	94.03.30
D	RE-DES	IGN		BW	95.01.04
E	RE-DES	IGN	BW	95.01.04	
F	REDES	GN; R1.200 WAS 1	.100	CP	89.12.13
G	STAND	WN IN SOLIDWORK ARDS, REFER TO S TO PREVENT CHA LATION.	AJS	09.01.16	

DESIGN	Буу	DART AEROSPACE LTD			
DRAWN	AJ I S	HAWKESBURY, ONTARIO, CANADA			
CHECKED	1	DRAWING NO.	REV. G		
MFG. APPR.	C/rd/.	D2230	SHEET 1 OF 3		
APPROVED	M	TITLE	SCALE		
DE APPR.	-	MOUNTING LUG	NTS		
DATE 09.0	1.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IN PRINCE DESIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR MY PLEPOISE ON COMBO ON PROMEMORIZED TO ANY OTHER PERSON WITHOUT WRITTEN PRINCESS ON PROMEMORIZE TO.			

NOTES:
1) MATERIAL: MAKE FROM D2423 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ±0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015±0.005.
7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

D

С

8

D

С

В

